



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL

2. ALL WELDS JOINING BELLOWS AND FLANGES ARE TO BE INTERNAL

3. BELLOWS ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2×10^{-10} STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS
ALCATEL SAM-110TCL
Du PONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18

CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TRESTING.

FINAL TEST WILL CONSIST OF SURROUNDING THE ASSEMBLY (BAGGING) WITH HELIUM. THE ASSEMBLY WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.

4. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.

5. DIMENSIONS IN [] ARE MILLIMETERS

REF. SOURCES

2 STANDARD BELLOWS CO.
375 TUNPIKE AVE.
WINDSOR LOCKS, CONN. 06096

1 MDC VACUUM PRODUCTS CORP.
23842 CABOT BLVD.
HAYWARD, CA. 94545-1651



3		ST'D. BELLOWS CAT. #750 - 600 - 5 - EE	WITH EXTENDED ENDS	1
2	MDC'S CAT. #100031	8" CF. ROTATABLE FLANGE		1
1	MDC'S CAT. #110031	8" CF. NONROTATABLE FLANGE		1

ITEM	QTY/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
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PARTS LIST

UNLESS OTHERWISE SPECIFIED, ALL DIMENSIONS ARE IN INCHES
TOLERANCES
DECIMALS ANGLES
X .03 (.7620) .25
XX .01 (.025)
XXX .005 (.127)
SURFACE ROUGHNESS 125
REMOVE ALL BURRS AND BREAK SHARP EDGES TO RAZ.
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST ASST. MFG. PRACTICES & TOLERANCES IN ACCORDANCE WITH LATEST ASST. MFG.

A14772

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DRAWN BY MUSCIA DATE 2/17/93
CHECKED BY
DESIGNER MUSCIA
RESPONSIBLE ENGINEER

CHIEF DESIGN ENGINEER DATE
OP LEADER
PROJECT MGR
APPROVED/RELEASED

TITLE ADVANCED PHOTON SOURCE
V2-93 WELDED BELLOWS ASSY.
8" - 8" CF. 6" I.D. X 200mm

MATERIAL SEE PARTS LIST

SCALE HALF SIZE
SHEET 1 of 1

DRAWING NUMBER 4105090702-930000-00

SYN	CHANGE DESCRIPTION	BY	CHKD	DATE
	REVISIONS			